

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003576**Date Inspected:** 04-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Bay 3 – Tower Heavy Machine Shop

The QA Inspector observed ZPMC qualified welder Dong Hu Yong Cang ID 203805 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP325-001 and DP244-001.

The QA Inspector inventoried 28 deck panels, and observed 14 ZPMC personnel performing general grinding on various deck panel repair welds.

Bay 1 – OBG Shop

The QA Inspector observed tack weld grinding in progress on DP576-001 by ZPMC personnel at Gantry #1, after the grinding of tack welds ZPMC Magnetic Particle Technician Cai Xin Xin performed MT testing and found 3 longitudinal cracks ranging in length from 3 to 7 millimeters, the cracks were removed by further grinding.

The QA Inspector observed Submerged Arc Welding (SAW) being performed at Gantry # 2 on DP360-001, after the welding was completed the QA Inspector observed weld # 10 U-rib 335 had approximately 1000mm of incomplete fusion.

The QA Inspector noticed the welder starting to grind the (IF) location and the ZPMC CWI Inspector Li Yan Hua was informed by the QA Inspector that the deck panel had not received a 3 party initial visual inspection for repair

WELDING INSPECTION REPORT

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welding identification. The CWI decided to stop the welding and have the deck panel scheduled to be repaired at the Heavy duty Tower Repair Shop.

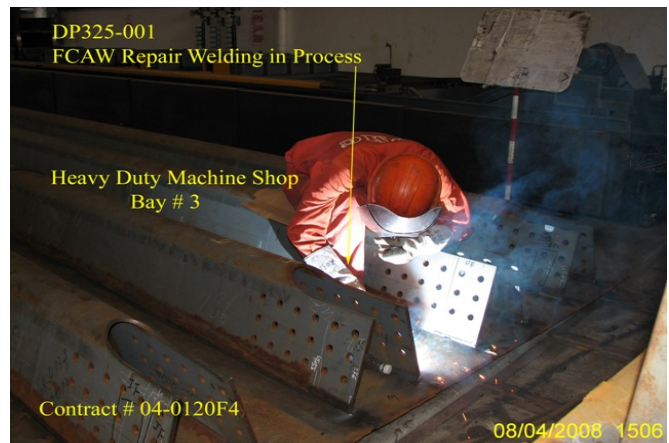
No Incident Report was issued since the repair was stopped and the deck panel was scheduled to be repaired in the designated repair shop where the 3 party inspections take place prior to repair welding being performed.

The QA Inspector also observed various work being performed by ZPMC personnel on deck panel sections such as drilling of holes in u-ribs, grinding of paint from plate material at areas where u-ribs are to be welded.

The QA Inspector observed the Flux Cored Arc welding in progress of various U-ribs CJP butt splices by ZPMC qualified and approved welder Dong Yi Qun ID 059450.

The welding in progress appeared to comply with the WPS posted at the welding station, and the contract requirements.

For more detail see photographs shown below:



Summary of Conversations:

As noted within the report shown above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dixon,Roscoe	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
